

Work Order ID 83002

Thursday, April 12, 2012 11:16:23 AM

83002

Page 1

Item ID: D350-689-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Dual High Back Seat Assembly

Start Date: 4/12/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/24/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12/04/12

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D350-689	B

100 0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-689-043 CHG002

110 0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

Assemble as per IIN 350-689

①

12 12-6-20

P/B

120 0.00

120

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

M 12 06 21 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
W-C-20	—	CHEMICAL CONVERSION CONT. PER QS1005. PERMANENT CHANGE..	ZH	12-6-20	2		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83002

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Page 2

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Item ID: D350-689-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Dual High Back Seat Assembly

Start Date: 4/12/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/24/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130									
Powdercoat									
Powder Coating									
	Memo								
	START TIME: 3:00	0.00							
	OVEN TEMPERATURE: 320 °F								
	FINISH TIME: 3:30								
140	QC3- Inspect Part Finish	0.00							
140									
QC									
Quality Control									
	Memo								
150	Large Fab	0.00							
150									
Large Fab									
Large Fab									
	Memo								
	Assemble as per IIN 350-689								

W121279

START: 1:50
OVENT: 3:20
FINISH: 2:30

10:06:21

1X

1

1

1X

M-L
12/06/20

ADG 01.

12-06-20

12/06/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Thursday, April 12, 2012 11:16:23 AM

Item ID: D350-689-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Dual High Back Seat Assembly

Start Date: 4/12/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 4/24/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

1 12 06 22

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

PPP 85764

0.00

Packaging

Ref 22 0

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12 06 22
MLJ 12 06 22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

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Page 1

Work Order ID: 83002

83002

Parent Item: D350-689-043

D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-12-24 new issue DD verified by:ECI PP Rev:B as per
DSI 9498 DD 10.02.12 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3017-041		Manufactured	No			110	Each	0.0000	1	1			
-----------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3017-041

Back Frame Assembly

83004x1

**

12-6-20

D3023-1		Manufactured	No			110	Each	1.0000	1	1			
---------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3023-1

Back Panel

**

12-6-20

Location

Loc Qty

Loc Code

82234x1

WA

1

79302

1

MS20600-AD4W2		Purchased	No			110	Each	277.0000	40	40			
---------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

MS20600-AD4W2

Rivet

**

12/06/21

Location

Loc Qty

Loc Code

ST321

277

116391

5

116471

4

116805

4

117601

1

117885

10

119638

3

120142

150

121011

100

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 2

Work Order ID: 83002

83002

Parent Item: D350-689-043

D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 1.00

Required Qty: 1.00

AN3-12A	Purchased	No	150	Each	52.0000	3	3	
AN3-12A						**		
Bolt								
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
		ST351		52				
		114536		1				
		119641		51				
D3016-041	Manufactured	No	150	Each	0.0000	1	1	
D3016-041						**		
Seat Frame Assembly								
D3021-041	Manufactured	No	150	Each	0.0000	1	1	
D3021-041						**		
Tube Assembly								
D3022-1	Manufactured	No	150	Each	4.0000	1	1	
D3022-1						**		
Seat Pan								
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
		WA		4				
		82235		4				
D3024-1	Manufactured	No	150	Each	10.0000	3	3	
D3024-1						**		
Spacer								
		<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>			
		ST023		10				
		77074		10				

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 83002

83002

Parent Item: D350-689-043

D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3031-1
D3031-1
Loop

Manufactured No

150 Each 17.0000 2 2

**

EP 12/06/22

Location

Loc Qty

Loc Code

GA

17

70016

9

79747

8

2

D3808-041
D3808-041
Seat Rail Assembly

Manufactured No

150 Each 0.0000 2 2

*B83005 (2) ***

EP 12/06/22

D3809-1
D3809-1
Sliding Block

Manufactured No

150 Each 9.0000 4 4

**

EP 12/06/22

Location

Loc Qty

Loc Code

ST064

9

70012

9

4

MS20600-AD4W3
MS20600-AD4W3
Cherry Rivets

Purchased No

150 Each 1,124.000 6 6

**

EP 12/06/21

Location

Loc Qty

Loc Code

ST321

991

111636

36

117601

17

118626

598

120308

340

WA018

133

107939

133

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 83002

83002

Parent Item: D350-689-043

D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3 Purchased No

150 Each

2,995.000

17

17

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

2995

117441

16

117885

32

118451

5

118927

3

119017

1773

119075

166

121349

1000

EP 12/06/22

M121444
(17X)

MS21042L4 Purchased No

150 Each

3,825.000

6

6

MS21042L4

Nut

**

Location

Loc Qty

Loc Code

ST300

3825

116188

5

119017

4

119075

1816

121011

2000

EP 12/06/22

M121444
(6X)

MS24693-S272 Purchased No

150 Each

313.0000

4

4

MS24693-S272

Screw

**

Location

Loc Qty

Loc Code

GA

296

118352

296

ST288

17

116391

11

116737

2

117977

4

EP 12/06/22

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 83002

83002

Parent Item: D350-689-043

D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 1.00

Required Qty: 1.00

MS24694-S148

Purchased

No

150

Each

22.0000

4

4

MS24694-S148

Screw

**

Location

Loc Qty

Loc Code

ST289A

22

108960

22

MS24694-S3

Purchased

No

150

Each

106.0000

8

8

MS24694-S3

Screw

**

Location

Loc Qty

Loc Code

ST289

106

108936

7

118354

99

MS27039-1-17

Purchased

No

150

Each

124.0000

4

4

MS27039-1-17

Screw

**

Location

Loc Qty

Loc Code

GA

100

120142

100

ST291

24

117591

24

MS27039-1-19

Purchased

No

150

Each

36.0000

6

6

MS27039-1-19

Screw

**

Location

Loc Qty

Loc Code

ST292

36

112794

36

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 83002

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Parent Item: D350-689-043

D350-689-043

Parent Item Name: Dual High Back Seat Assembly

Start Date: 4/12/2012

Required Date: 4/24/2012

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-21

Purchased

No

150

Each

33.0000

6

6

MS27039-4-21

Screw

**

Location

Loc Qty

Loc Code

ST292

33

114055

1

117977

4

118429

28

NAS1149D0332J

Purchased

No

150

Each

3,025.000

17

17

NAS1149D0332.J

Washer

**

Location

Loc Qty

Loc Code

ST298

3025

105793

12

110985

4

117087

89

119042

38

119717

554

120644

328

121011

2000

NAS1149D0432J

Purchased

No

150

Each

183.0000

6

6

NAS1149D0432.J

WASHER

**

Location

Loc Qty

Loc Code

ST298

183

116583

139

116584

44

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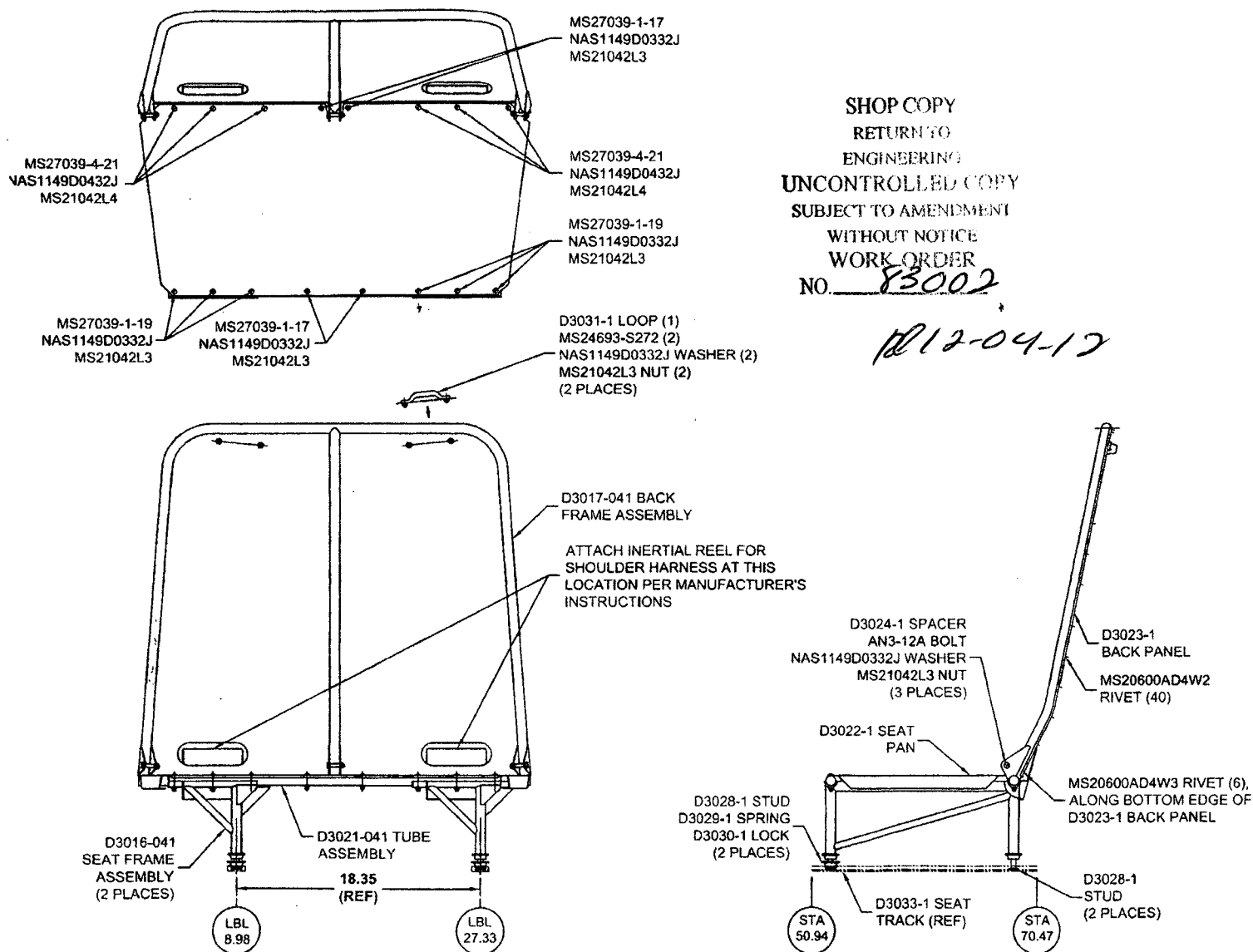
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 83002

12-04-12

FIGURE 9: Installation of D350-689-041 Dual High Back Seat Assembly

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Revision: **B**
 Date: 11.07.22

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
1						1			D3026-1	CHANNEL
1									D3027-1	CLIP
1									D3027-3	CLIP
1									D3027-5	CLIP
4						4			D3027-7	CLIP
							4		D3028-1	STUD
		2					2		D3029-1	SPRING
		2					2		D3030-1	LOCK
							2	2	D3031-1	LOOP
1									D3032-1	SPACER
2	1								D3033-1	SEAT TRACK
	4								D3059-1	STUD
	4								D3060-1	BUSHING
	4								D3061-1	RADIUS BLOCK
				1					D3084-3	STRUT
1									D3234-1	DOUBLER
1						1			D3234-3	DOUBLER
2									D3234-5	SPACER
								2	D3808-041	SEAT RAIL ASSEMBLY
								4	D3809-1	SLIDING BLOCK
						1			D3811-041	SEAT TRACK ASSEMBLY
			2						D4071-041	SHOULDER HARDNESS ASSY
							3	3	AN3-12A	BOLT
				1					AN4-12A	BOLT
				1					AN4-20A	BOLT
			2						AN5-4A	BOLT
							40	40	MS20600AD4W2	RIVET
							6	6	MS20600AD4W3	RIVET
						9	17	17	MS21042L3	NUT (OR MS21042-3)
				2			6	6	MS21042L4	NUT (OR MS21042-4)
	4	2							MS21042L5	NUT (OR MS21042-5)
12	4								MS21059L3	NUTPLATE
							4	4	MS24693-S272	SCREW
2	1								MS24693-S273	SCREW
								8	MS24694-S3	SCREW
						9			MS24694-S50	SCREW
								4	MS24694-S148	SCREW
6	3								MS27039-1-10	SCREW
							4	4	MS27039-1-17	SCREW
							6	6	MS27039-1-19	SCREW
							6	6	MS27039-4-21	SCREW
6	3						17	17	NAS1149D0332J	WASHER (OR AN960JD10L)
						9			NAS1149D0363J	WASHER (OR AN960JD10)
				8					NAS1149D0416J	WASHER (OR AN960JD416L)
							6	6	NAS1149D0432J	WASHER (OR AN960JD416)
			4						NAS1149D0516J	WASHER (OR AN960JD516L)
	4								NAS1149D0563J	WASHER (OR AN960JD516)
				2					NAS43DD4-46N	SPACER

83002

83002

4. WEIGHT AND BALANCE

The following weight and balance information is for the Dart Dual High Back Seat Installation. The weight and balance of the parts that are removed from the aircraft to perform this installation are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-011 Dual High Back Seat Installation, Fwd Position	27.6 lb 12.5 kg	-18.2 in -0.46 m	-502 in-lb -5.8 m-kG	60.7 in 1.54 m	1675 in-lb 19.3 m-kG
D350-689-013 Floor Provisions Kit, Fwd Position	2.0 lb 0.9 kg	-18.2 in -0.46 m	-36 in-lb -0.4 m-kG	60.7 in 1.54 m	121 in-lb 1.4 m-kG
D350-689-011 Dual High Back Seat Installation, Aft Position	28.1 lb 12.7 kg	-18.2 in -0.46 m	-511 in-lb -5.8 m-kG	63.7 in 1.62 m	1790 in-lb 20.57 m-kG
D350-689-013 Floor Provisions Kit, Aft Position	3.1 lb 1.4 kg	-18.2 in -0.46 m	-56 in-lb -0.6 m-kG	62.2 in 1.58 m	193 in-lb 2.2 m-kG
D350-689-015 Seat Modification Kit	1.0 lb 0.5 kg	-17.2 in -0.44 m	-17 in-lb -0.22 m-kG	60.7 1.54 m	61 in-lb 0.77 m-kG
D350-689-017 Shoulder Harness, Fwd Position	4.4 lb 2.00 kg	-18.2 in -0.46 m	-80.1 in-lb -0.92 m-kG	60.7 in 1.54 m	267 in-lb 3.08 m-kG
D350-689-017 Shoulder Harness, Aft Position	4.4 lb 2.00 kg	-18.2 in -0.46 m	-80.1 in-lb -0.92 m-kG	64.7 in 1.64 m	285 in-lb 3.28 m-kG
D350-689-019 Control Guard, Fwd Position	0.5 lb 0.23 kg	-9.0 in -0.23 m	-4.5 in-lb -0.05 m-kG	60.7 in 1.54 m	30 in-lb 0.35 m-kG
D350-689-019 Control Guard, Aft Position	0.5 lb 0.23 kg	-9.0 in -0.23 m	-4.5 in-lb -0.05 m-kG	64.7 in 1.64 m	32 in-lb 0.38 m-kG
D350-689-021 Dual High Seat Back Installation, LH Fwd Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-kG	60.7 in 1.54 m	1772 in-lb 20.3 m-kG
D350-689-021 Dual High Seat Back Installation, LH Aft Position	29.2 lb 13.2 kg	-18.2 in -0.46 m	-531 in-lb -6.1 m-kG	64.7 in 1.64 m	1889 in-lb 21.6 m-kG
D350-689-023 Energy Attenuating Floor Provisions Kit	2.5 lb 1.1 kg	-18.2 in -0.46 m	-46 in-lb -0.5 m-kG	62.2 in 1.58 m	156 in-lb 1.7 m-kG

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X									D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X								D350-689-013	FLOOR PROVISIONS KIT
		X							D350-689-015	SEAT MODIFICATION KIT
			X						D350-689-017	SHOULDER HARNESS KIT
				X					D350-689-019	CONTROL GUARD KIT
					X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH
					1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISIONS KIT
1							X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
					1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY
							2	2	D3016-041	SEAT FRAME ASSEMBLY
							1	1	D3017-041	BACK FRAME ASSEMBLY
1					1				D3018-1	SEAT CUSHION
1					1				D3019-1	BACK CUSHION
							1	1	D3021-041	TUBE ASSEMBLY
							1	1	D3022-1	SEAT PAN
							1	1	D3023-1	BACK PANEL
							3	3	D3024-1	SPACER
	1								D3025-1	BEAM

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